

Date: Friday, 23/03/2007 8:25:45 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 31446	Part Number	: D35602
Estimate Number	: 12579	Drawing Number	: D3560 <u>UNDER REVIEW</u> <i>for replacement</i>
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 23/03/2007 S.O. No. : N/A	Drawing Revision	: A
Prsh Rev.	: NC	Material	: <i>N/A</i>
First Issue	: N/A	Due Date	: 26/03/2007 Qty: 3 Um: Each
Previous Run	: 30538		
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev A New Issue 06-11-10 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
	Comment: Qty.: 1.0080 f(s)/Unit Total : 3.0240 f(s) 6061-T6 Bar .50" x 6.0" Batch: <i>M101919</i> <i>mL 07 03 23</i>	(3)
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3560 Dwg Rev: <i>A</i> Prog Rev: <i>A</i> <i>mL 07 03 23</i>	(3)
	2-Deburr if necessary	
	Note: .507" Dia & .196" Dia Holes are to opened on manual mill after Waterjet	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	(3)
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE 1-Open .196" Dia hole 2-C'Bore as per Dwg D3560. 3-Ream .507" as per Dwg D3560 ***Ensure to C'Bore on Corect side***	<i>M8 07/03/23</i> (3)

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5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F - 07/03/26 (3)

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F - 07/03/26 (3)

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WIP

J.F - 07/03/26 (3)

8.0	QC21	FINAL INSPECTION/W/O RELEASE
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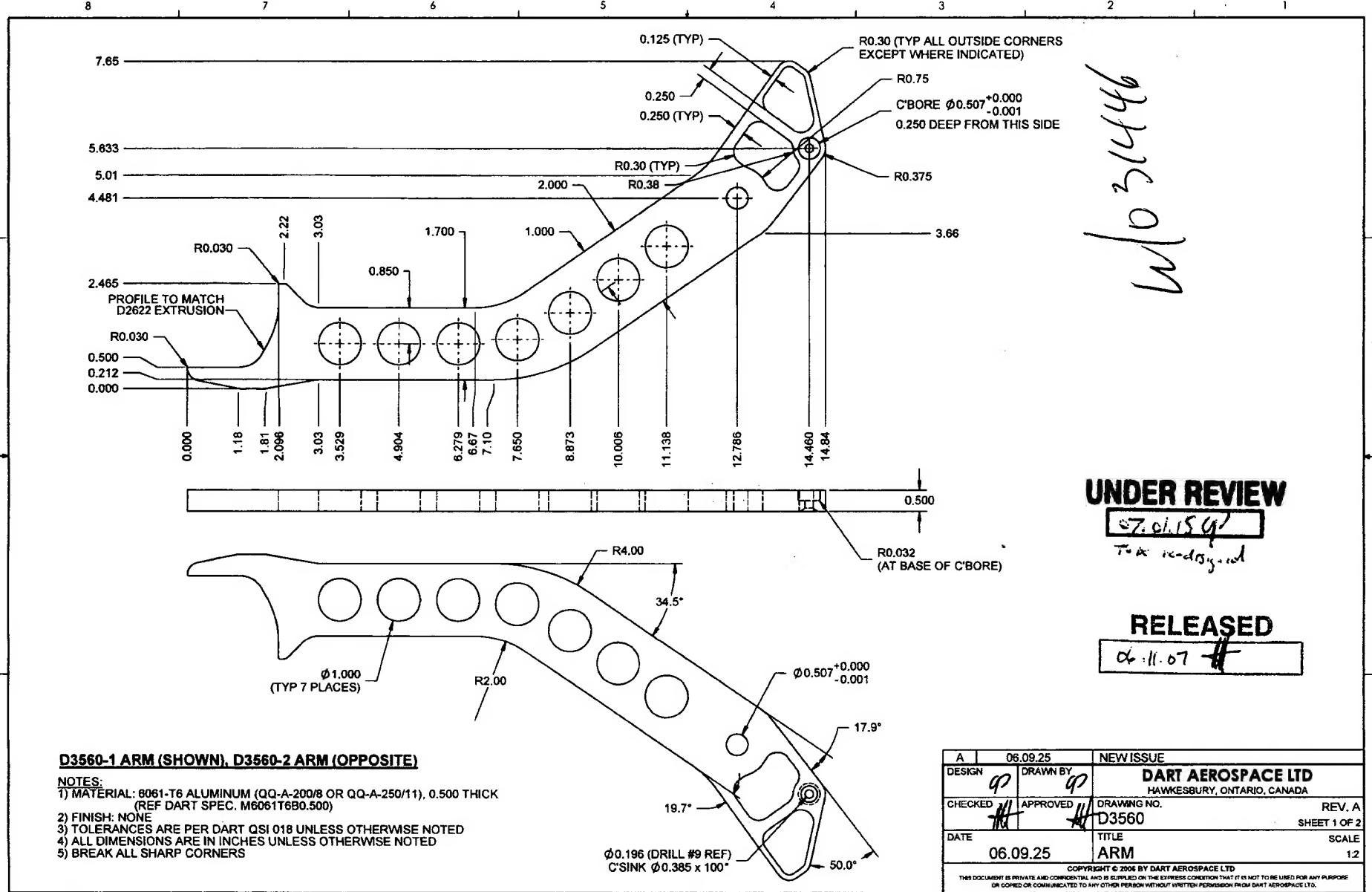
Comment: FINAL INSPECTION/W/O RELEASE

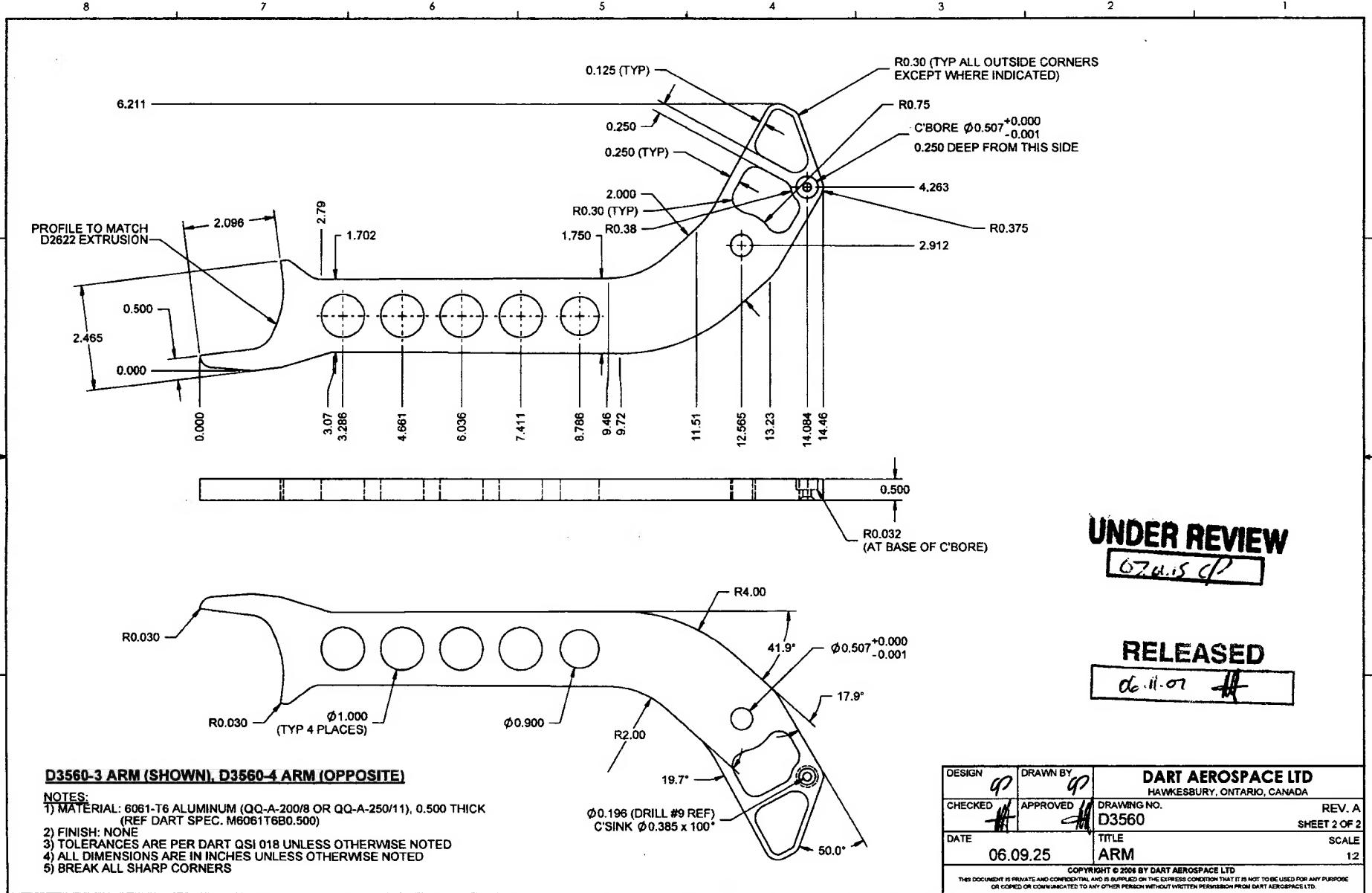
J.F - 07/03/26

Job Completion



J.F - 07/03/26





DART AEROSPACE LTD	Work Order:	31446
Description: ARM	Part Number:	D3560-2
Inspection Dwg: D3560 Rev: 1A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 1.000$	+0.012 -0.001	1.000	✓		VERN	
B $\phi 0.507$	+0.008 -0.001	0.507	✓		VERN	
C $\phi 0.196$	+0.005 -0.001	0.201	✓		VERN	
D 0.500	+/- 0.010	0.503	✓		VERN	
E 0.465	+/- 0.010	0.465	✓		VERN	
F 0.250	+/- 0.010	0.249	✓		VERN	
G 0.125	+/- 0.010	0.125	✓		VERN	
H 2.000	+/- 0.010	2.000	✓		VERN	
I 1.700	+/- 0.010	1.701	✓		VERN	
J 0.850	+/- 0.010	0.852	✓		VERN	
K 1.000	+/- 0.010	1.000	✓		VERN	
L $.507$	$+.000$ $-.001$.507	✓			
M $.385 \times 10^3$	$+.010$.385	✓			
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	ML. M.	Audited by:		Prototype Approval:	N/A
Date:	07 03 23	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	